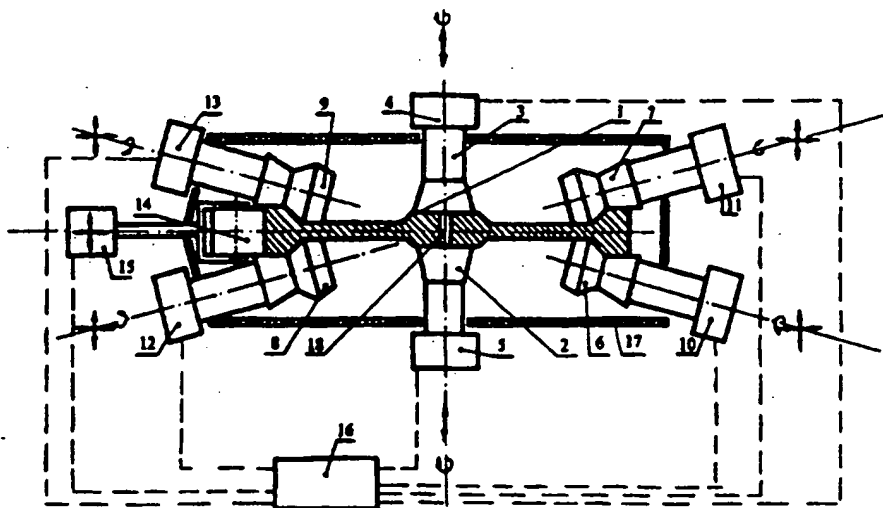


INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B21H 1/04, C22F 1/10	A1	(11) International Publication Number: WO 97/48509 (43) International Publication Date: 24 December 1997 (24.12.97)
(21) International Application Number: PCT/US97/10673 (22) International Filing Date: 19 June 1997 (19.06.97) (30) Priority Data: 96112649 21 June 1996 (21.06.96) RU (71) Applicants (for all designated States except US): GENERAL ELECTRIC COMPANY [US/US]; 1 River Road, Schenectady, NY 12345 (US). INSTITUTE FOR METALS SUPERPLASTICITY PROBLEMS OF THE RUSSIAN ACADEMY OF SCIENCES [RU/RU]; Khalturina Street 39, Ufa, Bashkortostan, 450001 (RU). (72) Inventors; and (75) Inventors/Applicants (for US only): UTYASHEV, Farid Zainullaevich [RU/RU]; Apartment 5, Shafieva Street 41, Ufa, Bashkortostan, 450096 (RU). KAIBYSHEV, Oscar Akamovich [RU/RU]; Apartment 28, Lenina Street 31/33, Ufa, Bashkortostan, 450005 (RU). VALITOV, Vener Anvarovich [RU/RU]; Apartment 97, Akhmetova Street, 300/2, Ufa, Bashkortostan, 450017 (RU). (74) Agents: CHASKIN, Jay, L.; General Electric Company, 3135 Easton Turnpike W3C, Fairfield, CT 06431 (US) et al.		(81) Designated States: JP, KR, US, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i> <div style="text-align: center;"> <p>RECEIVED</p> <p>NOV 09 1998</p> <p>INTERNATIONAL PATENT OPERATION GENERAL ELECTRIC COMPANY</p> </div>

(54) Title: METHOD FOR PRODUCING AXIALLY SYMMETRIC PARTS AND THE ARTICLE



(57) Abstract

The invention relates to plastic metal working, more specifically to methods for producing parts of the disk- or shell-type having conical, hemispherical, and also combined parts, such as disk-and-shaft ones. The invention is instrumental in producing large axially symmetric parts from hard-to-work multiphase alloys. The method consists in that the billet is heated in a temperature range above 0.4 m.p. but below the temperature at which a total content of precipitates or an allotropic modification of the matrix of a multiphase alloy is not below 7 %. Then the preheated billet is rolled, while controlling its temperature and the tool load, as well as the rolling speed. Once rolled the billet is heat-treated at a temperature depending on the microstructure of the billet material resulting from rolling. Prerolling preparing of a specified microstructure of the billet material is also described.